

**Amendments to the Claims**

This listing of claims replaces all prior versions, and listings, of claims in the application.

## Listing of Claims

~~{1}~~ 1. (Currently amended) An electrophotographic developing roller having a cylindrical metal base body and a metal flange as press fitted in an opening end section of said cylindrical metal base body, ~~the developing roller being characterized in that~~ wherein said metal flange has a larger diameter section for fitting in ~~the~~ an opening end section inner surface of said cylindrical metal base body and a smaller diameter section serving as a central shaft body coaxial with said cylindrical metal base body; and ~~that the~~ wherein a fit section surface of said larger diameter section before being press fitted has an uneven shape such that a maximum roughness  $R_y$  due to a circumferential groove formed by cutting processing is from 25  $\mu\text{m}$  to 70  $\mu\text{m}$ .

~~{2}~~ 2. (Currently amended) An electrophotographic developing roller having a cylindrical metal base body and a metal flange as press fitted in an opening end section of said cylindrical metal base body, ~~the developing roller being characterized in that~~ wherein said metal flange has a larger diameter section for fitting in ~~the~~ an opening end section inner surface of said cylindrical metal base body and a smaller diameter section serving as a central shaft body coaxial with said cylindrical metal base body; and ~~that the~~ wherein a fit section surface of the opening end section inner surface of said cylindrical metal base body before being press fitted has an uneven shape such that a maximum roughness  $R_y$  due to a circumferential groove formed by cutting processing is from 25  $\mu\text{m}$  to 70  $\mu\text{m}$ .

~~{3}~~ 3. (Currently amended) The electrophotographic developing roller according to claim 1 ~~or 2, characterized in that~~ wherein an adhesive is used in said fit section.

~~{4}~~ 4. (Currently amended) The electrophotographic developing roller according to claim 3, ~~characterized in that~~ wherein said adhesive is an anaerobic adhesive.

~~{5}~~ 5. (Currently amended) The electrophotographic developing roller according to ~~any one of claims 1 to 4~~ claim 1, ~~characterized in that~~ wherein a countersunk section is provided on the opening end section inner surface of said cylindrical metal base body.

~~{6}~~ 6. (Currently amended) The electrophotographic developing roller according to ~~any one of claims 1 to 5~~ claim 1, ~~characterized in that the~~ wherein a thickness of said cylindrical metal base body is from 0.75 mm to 2 mm; and ~~that the~~ an interference at ~~the~~ a time of press fitting is from 10  $\mu$ m to 60  $\mu$ m.

~~{7}~~ 7. (Currently amended) The electrophotographic developing roller according to ~~any one of claims 1 to 6~~ claim 1, ~~characterized in that~~ wherein said cylindrical metal base body and said metal flange are each made of steel or an aluminum based alloy as ~~the~~ a principal material.

~~{8}~~ 8. (Currently amended) The electrophotographic developing roller according to ~~any one of claims 1 to 6~~ claim 1, ~~characterized in that~~ wherein said cylindrical metal base body is made of a carbon steel tube containing not more than 0.25% by weight of carbon, not more than 0.30% by weight of silicon, and not more than 0.85% by weight of manganese.

~~+9+~~ 9. (Currently amended) An electrophotographic developing roller having at least a cylindrical metal base body, ~~which comes for coming~~ into contact with or ~~becomes becoming~~ adjacent to a photoreceptor, thereby feeding a developer on ~~the~~ a surface of said photoreceptor and developing an electrostatic latent image formed on said photoreceptor, ~~the developing roller being characterized in that~~ wherein said cylindrical metal base body is made of a carbon steel tube containing not more than 0.25% by weight of carbon, not more than 0.30% by weight of silicon, and not more than 0.85% by weight of manganese, respectively.

~~+10+~~ 10. (Currently amended) The electrophotographic developing roller according to ~~any one of claims 1 to 6~~ claim 1, ~~characterized in that~~ wherein said cylindrical metal base body is made of an STKM11A carbon steel tube (JIS G3445).

~~+11+~~ 11. (Currently amended) An electrophotographic developing roller having at least a cylindrical metal base body, ~~which comes for coming~~ into contact with or ~~becomes becoming~~ adjacent to a photoreceptor, thereby feeding a developer on ~~the~~ a surface of said photoreceptor and developing an electrostatic latent image formed on said photoreceptor, ~~the developing roller being characterized in that~~ wherein said cylindrical metal base body is made of an STKM11A carbon steel tube (JIS G3445).

~~+12+~~ 12. (Currently amended) The electrophotographic developing roller according to ~~any one of claims 1 to 11~~ claim 1, ~~characterized in that~~ wherein said cylindrical metal base body is an electro-resistance-welded tube.

~~{13}~~ 13. (Currently amended) The electrophotographic developing roller according to ~~any one of claims 1 to 12~~ claim 1, ~~characterized in that~~ wherein said cylindrical metal base body is subjected to cutting processing or polishing processing.

~~{14}~~ 14. (Currently amended) The electrophotographic developing roller according to ~~any one of claims 1 to 13~~ claim 1, ~~characterized in that the~~ wherein an outer surface of said cylindrical metal base body is subjected to a blast treatment.

~~{15}~~ 15. (Currently amended) The electrophotographic developing roller according to ~~any one of claims 1 to 13~~ claim 1, ~~characterized in that the~~ wherein an outer surface of said cylindrical metal base body is subjected to metal plating.

~~{16}~~ 16. (Currently amended) The electrophotographic developing roller according to claim 14, ~~characterized in that~~ wherein the outer surface of said cylindrical metal base body having been subjected to a blast treatment is further subjected to metal plating.

~~{17}~~ 17. (Currently amended) The electrophotographic developing roller according to claim 15 ~~or 16~~, ~~characterized in that~~ wherein said metal plating is electroless nickel plating.

~~{18}~~ 18. (Currently amended) The electrophotographic developing roller according to ~~any one of claims 15 to 17~~ claim 15, ~~characterized in that~~ wherein the outer surface of said cylindrical metal base body having been subjected to metal plating is further subjected to a chromate treatment.

~~{19}~~ 19. (Currently amended) The electrophotographic developing roller according to ~~any one of claims 15 to 18~~ claim 15, ~~characterized in that~~ wherein said metal plating is achieved without performing a zinc alloy film formation treatment in advance.

~~{20}~~ 20. (Currently amended) The electrophotographic developing roller according to ~~any one of claims 1 to 19~~ claim 1, ~~characterized in that~~ wherein said cylindrical metal base body has a straightness of not more than 15  $\mu\text{m}$ .

~~{21}~~ 21. (Currently amended) The electrophotographic developing roller according to ~~any one of claims 1 to 20~~ claim 1, ~~characterized in that~~ wherein said cylindrical metal base body has a deflection accuracy of not more than 20  $\mu\text{m}$ .

~~{22}~~ 22. (Currently amended) The electrophotographic developing roller according to ~~any one of claims 1 to 21~~ claim 1, ~~characterized in that~~ wherein said electrophotographic developing roller is used in an electrophotographic device of a non-magnetic one-component non-contact development system.

~~{23}~~ 23. (Currently amended) The electrophotographic developing roller according to ~~any one of claims 1 to 22~~ claim 1, ~~characterized in that~~ wherein said electrophotographic developing roller is used in a color electrophotographic device.

~~{24}~~ 24. (Currently amended) An image forming device, ~~characterized by being~~ wherein the image forming device is mounted with the electrophotographic developing roller according to ~~any one of claims 1 to 23~~ claim 1.